

Date: Tuesday, 12/5/2006 8:20:39 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 29825	
Estimate Number : 11198	
P.O. Number : N/A	Part Number : D3304041
This Issue : 12/5/2006 S.O. No. : N/A	Drawing Number : D3304 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 26763	Material : N/A
Written By :	Due Date : 12/23/2006 Qty: 4 Um: Each
Checked & Approved By : <u>06 12 05</u>	
Comment : Est: C 04.11.17 Step 13 revised KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0875W065	SS TUBING
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Comment: Qty.: 1.4109 f(s)/Unit Total: 5.6435 f(s)
 Material: AISI 304/316 SS tubing 0.875" x 0.065" wall
 (M304TR0.875W.065)
 Identify for D3304-1
 Batch: 116258 103090 BC 07/01/06

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 Cut blank: 15.75" as per Dwg D3304
 Turn as per Folio FA458 and Dwg D3304
 Identify as D3304-1

BC 07/01/06

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07.01.16

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MS 07/01/06

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr
 Drill as per Dwg D3304 using drill Jig D3304-T1
 Deburr

FF 07-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:20:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 29825

Part Number: D3304041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/22 (4)

7.0

D33045

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket

Pick:

Qty Part Number Description
1 D3304-75 Bracket

Batch
B23980

FC 07/08/20 (4)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004

FC 07/03/20 (4)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/20 (4)

10.0

POWDER COATING

POWDER COATING



M101601



(4x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/03/22

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/03/22 x4

12.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

PIP PIN

Pick:

Qty Part Number Description
1 BLBS-0016 Pip Pin

Batch

M16557X3

M16188 X1

ml 07/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/28

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:20:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 29825

Part Number: D3304041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Loop Sleeve

Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	M100644

14.0

CBL1240

Cable



Comment: Qty.: 1.0417 f(s)/Unit Total : 4.1668 f(s)

Cable

Pick:

Qty	Part Number	Description	Batch
12.5"	CBL-1240	Cable	M102439

m107/03/22

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x4

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

m107/03/26

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m107/03/26 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

m107/03/27

(4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

m107/03/28

Job Completion



m107/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

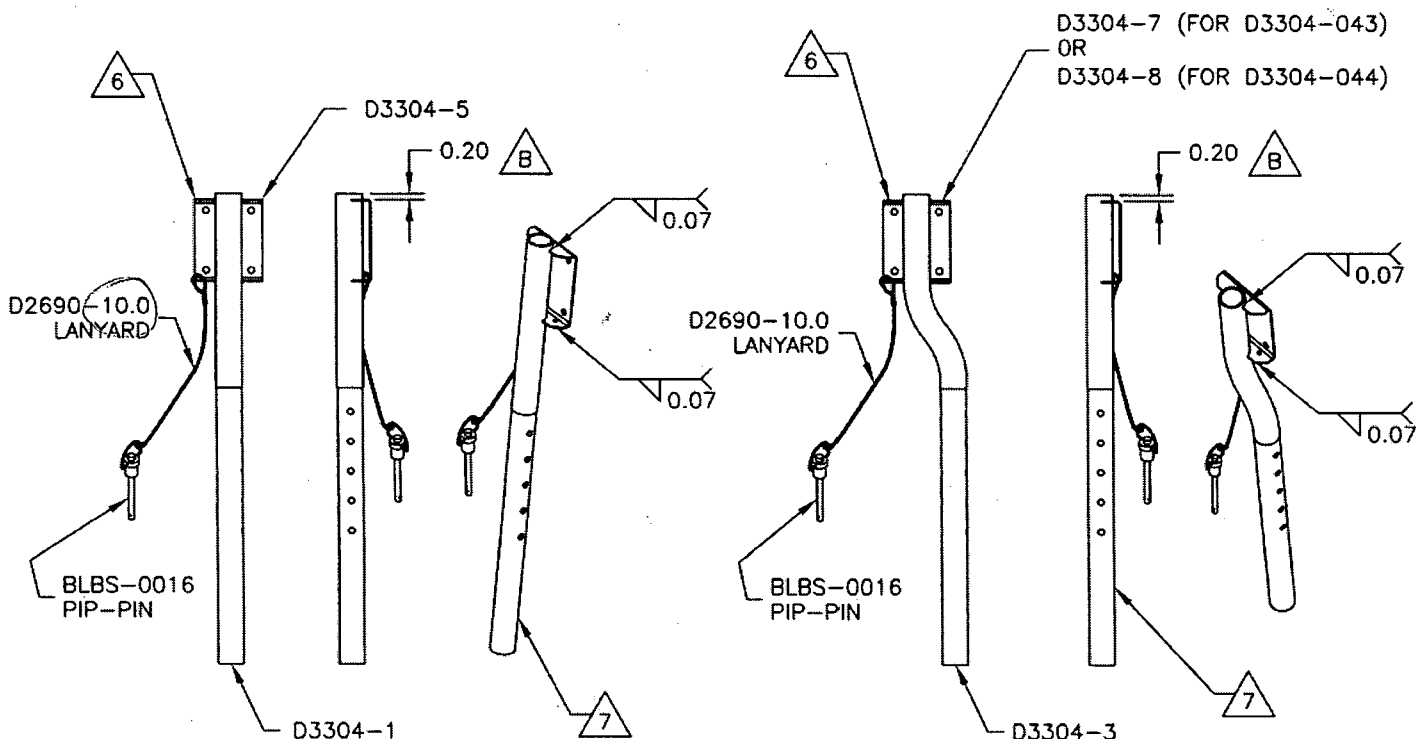
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3304
DATE	05.07.15			TITLE TUBE ASSEMBLY
	A	04.08.18		REV. B
	B	05.07.15		SCALE 1:6
				SHEET 1 OF 4
				UPDATE DIMENSIONS; ADD D3304-7/-8



**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

D3304-041 TUBE ASSEMBLY

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

NO. 29825
WORK ORDER
WITHOUT NOTICE
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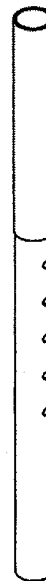
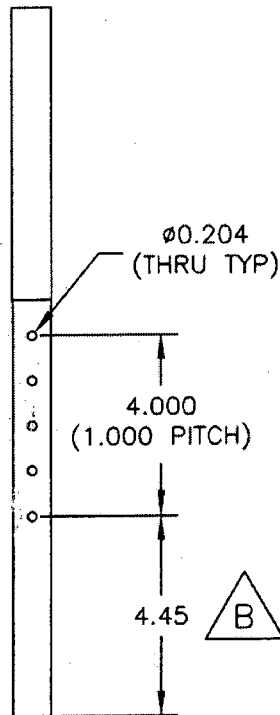
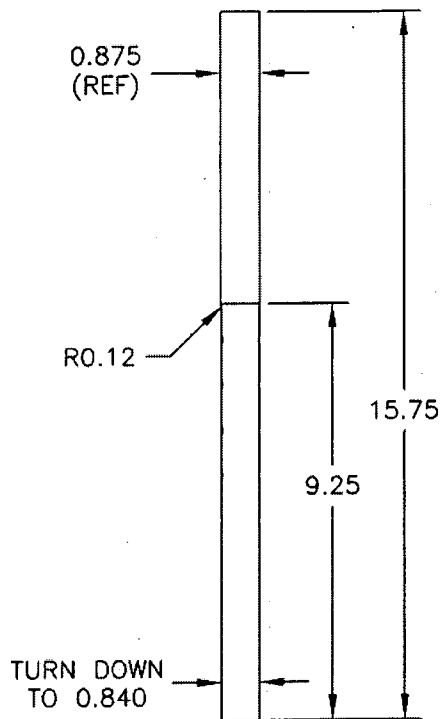
14 3/8
2.120

RELEASED
05.08.11



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CHECKED H	APPROVED H	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
05.08.11 H



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

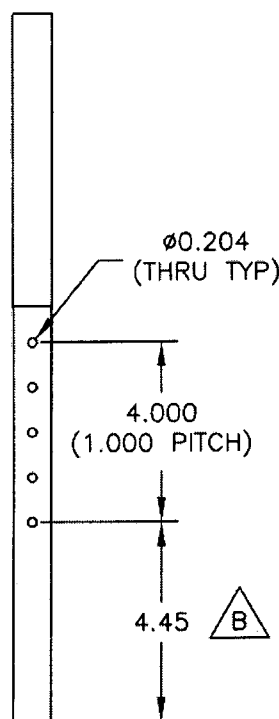
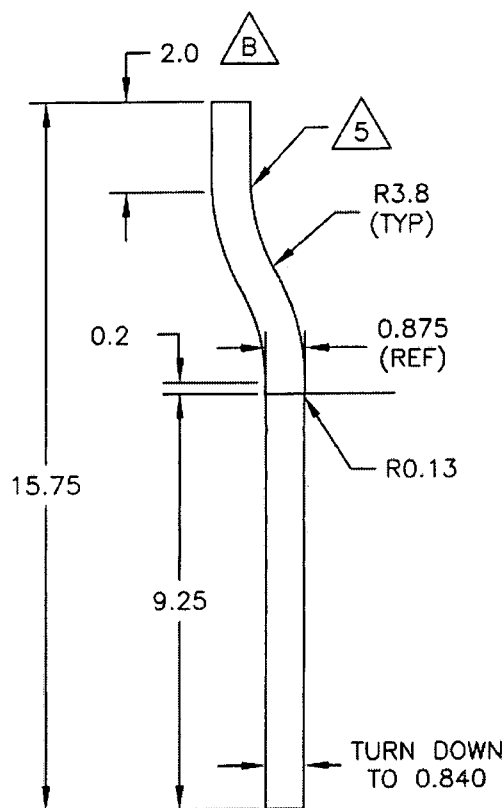
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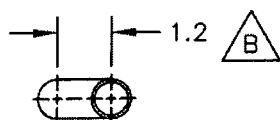
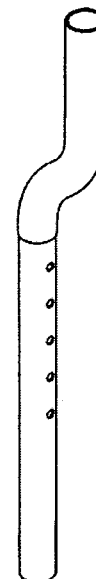
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



RELEASED
05-08-11 *[Signature]*



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

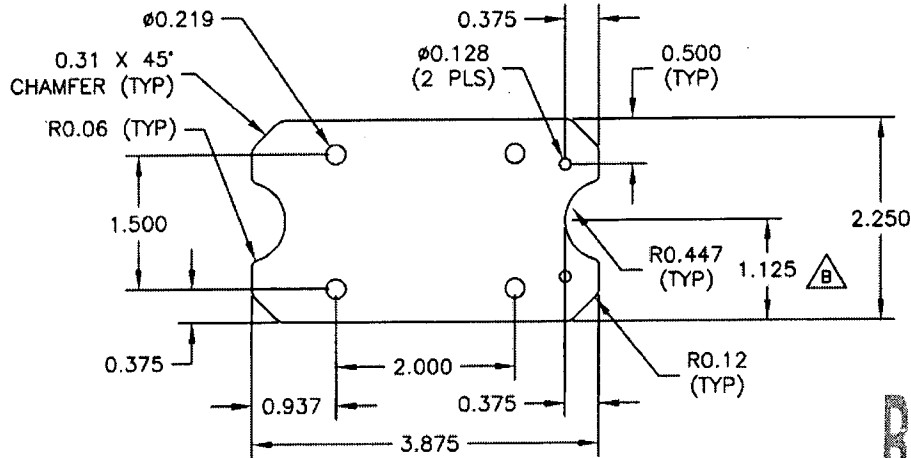
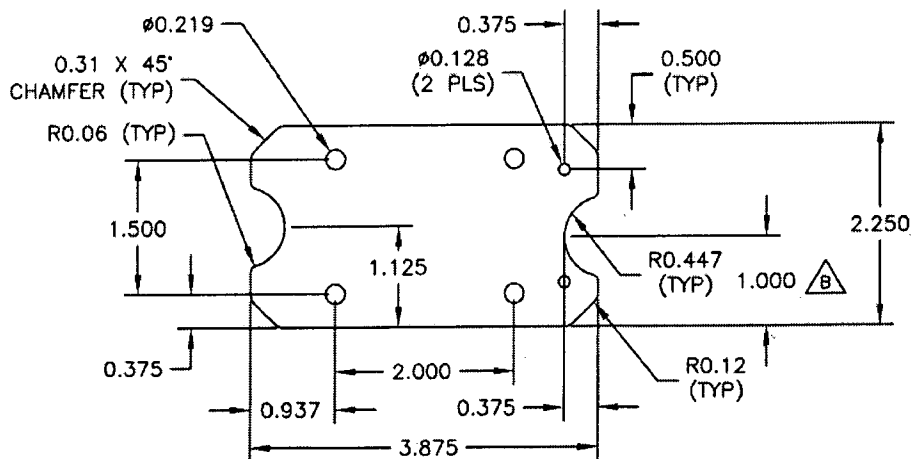
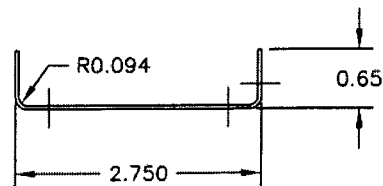
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:2

**D3304-5 FLAT PATTERN****D3304-7/-8 FLAT PATTERN****D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

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NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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